

Date: Tuesday, 15/08/2006 11:53:05 AM  
 User: Linda Lacelle

## Process Sheet

**Customer** : CU-DAR001 Dart Helicopters Services  
**Job Number** : 23342  
**Estimate Number** : 10609  
**P.O. Number** : N/A  
**This Issue** : 15/08/2006 **S.O. No.** : N/A  
**Prsh Rev.** : NC  
**First Issue** : N/A **Type** : PURCHASED PARTS  
**Previous Run** : 23342  
**Written By** : \_\_\_\_\_  
**Checked & Approved By** : \_\_\_\_\_  
**Comment** : Est: A 05.05.11 New issue KJ/JLM  
 Est Rev:B Now On Waterjet 06-08-15 JLM

**Drawing Name** : WEARPLATE  
**Part Number** : D33195  
**Drawing Number** : D3319 REV. B  
**Project Number** : N/A  
**Drawing Revision** : B  
**Material** : N/A  
**Due Date** : 22/08/2006 **Qty:** 10 **Um:** Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S18GA	1010/1025/A21/6aA SHEET .048 
		Comment: Qty.: 0.6888 sf(s)/Unit Total.: 6.8880 sf(s) 1010/1025 SHEET 18 GAUGE (.048" thk) (M1010S18GA) Batch: <u>M1010S18GA</u> <u>mf 06 08 23</u>
2.0	WATER JET	FLOW WATER JET 
		Comment: FLOW WATER JET 1-Cut as per Dwg D3319 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-Deburr if necessary <u>mf 06 08 23</u> <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">(10)</span>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>mf 06 08 28</u> <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">(10)</span>
4.0	QC8	SECOND CHECK 
		Comment: SECOND CHECK <u>mf 06 08 29</u> <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">(10)</span>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary <u>mf 06 08 29</u> <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">(10)</span>

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Drawing Name: WEARPLATE

Job Number: 23342

Part Number: D33195

Job Number:



Seq #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form using DT8326 & DT8261 as per Dwg D3319 Rev: B

SB 06/08/29 (10)

7.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK



8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using D3319-5T2 per QSI 004 and Dwg D3319 Rev: 3

(10)

Qty Part Number Description Batch  
A/R N/A 7560 Hardcoat Rod M100780

CPL 06.08.30

9.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION



M 06/08/31 (10)

10.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

FC 06 09 07 (10)

11.0 QC3 INSPECT POWDER COAT/ CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT



PC 06/08/07 (10)

12.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3319-5, B/N: BXXXXX

For Product Eligibility see PDA05-18

and Stock

Location: ST 361

06/08/07 (10)

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 23342

Part Number: D33195

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0

DC

DOCUMENT CONTROL



(18)

Comment: DOCUMENT CONTROL

Inspection Level 21

Do 06/09/11

Job Completion



U 26/09/11

Date: Tuesday, 15/08/2006 7:35:04 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPLATE	
Job Number	: 23342		Part Number	: D33195	
Estimate Number	: 10609		Drawing Number	: D3319 REV. B	
P.O. Number	:		Project Number	:	
This Issue	: 15/08/2006	S.O. No. :	Drawing Revision	: B	
Prsh Rev.	: NC		Material	:	
First Issue	: 17/11/2005	Type	: PURCHASED PARTS		
Previous Run	:		Due Date	: 03/04/2006 Qty: 10 Um: Each	
Written By	:				
Checked & Approved By	:				
Comment	: Est: A 05.05.11 New issue KJ/JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
	Comment: PURCHASING	1010 S1B6A 656 SF.
	Issue P/O:	
	Email or Ship DXF file to vendor	
	Laser Cut flat pattern per Dwg D3319	
	Possible Supplier: Industrial Laser	
	Material release note is required	
2.0	D33195F	Wearplate
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)	10/08/23 (10)
	WEARPLATE	
3.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1	
	Recieve & Inspect for Transit Damage	
	Ensure Material Release Note is attached	
4.0	QC6	DIMENSIONAL CHECK
	Comment: DIMENSIONAL CHECK	
	Inspect dimensions as per inspection template D3319-5T1	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1	
	Deburr if necessary	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/08/2006 7:35:04 AM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 23342

Part Number: D33195

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	BRAKE NC	NC BRAKE
	<b>Comment:</b> NC BRAKE Form using DT8326 & DT8261 as per Dwg D3319 Rev: _____	
7.0	QC6	DIMENSIONAL CHECK
	<b>Comment:</b> DIMENSIONAL CHECK	
8.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
	<b>Comment:</b> LARGE FABRICATION RESOURCE 1 Weld hard surface using D3319-5T2 per QSI 004 and Dwg D3319 Rev: _____	
	Qty Part Number Description Batch	
	A/R N/A 7560 Hardcoat Rod	
9.0	QC9	VISUAL WELDING INSPECTION
	<b>Comment:</b> VISUAL WELDING INSPECTION	
10.0	POWDER COATING	POWDER COATING
	<b>Comment:</b> POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3	
11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	<b>Comment:</b> INSPECT POWDER COAT	
12.0	PACKAGING 1	PACKAGING RESOURCE #1
	<b>Comment:</b> PACKAGING RESOURCE #1 Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. P/N: D3319-5, B/N: BXXXXX For Product Eligibility see PDA05-18 and Stock Location: _____	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/08/2006 7:35:04 AM  
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**Customer:** CU-DAR001 Dart Helicopters Services

**Drawing Name:** WEARPLATE

**Job Number:** 23342

**Part Number:** D33195

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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13.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Inspection Level 21

Job Completion

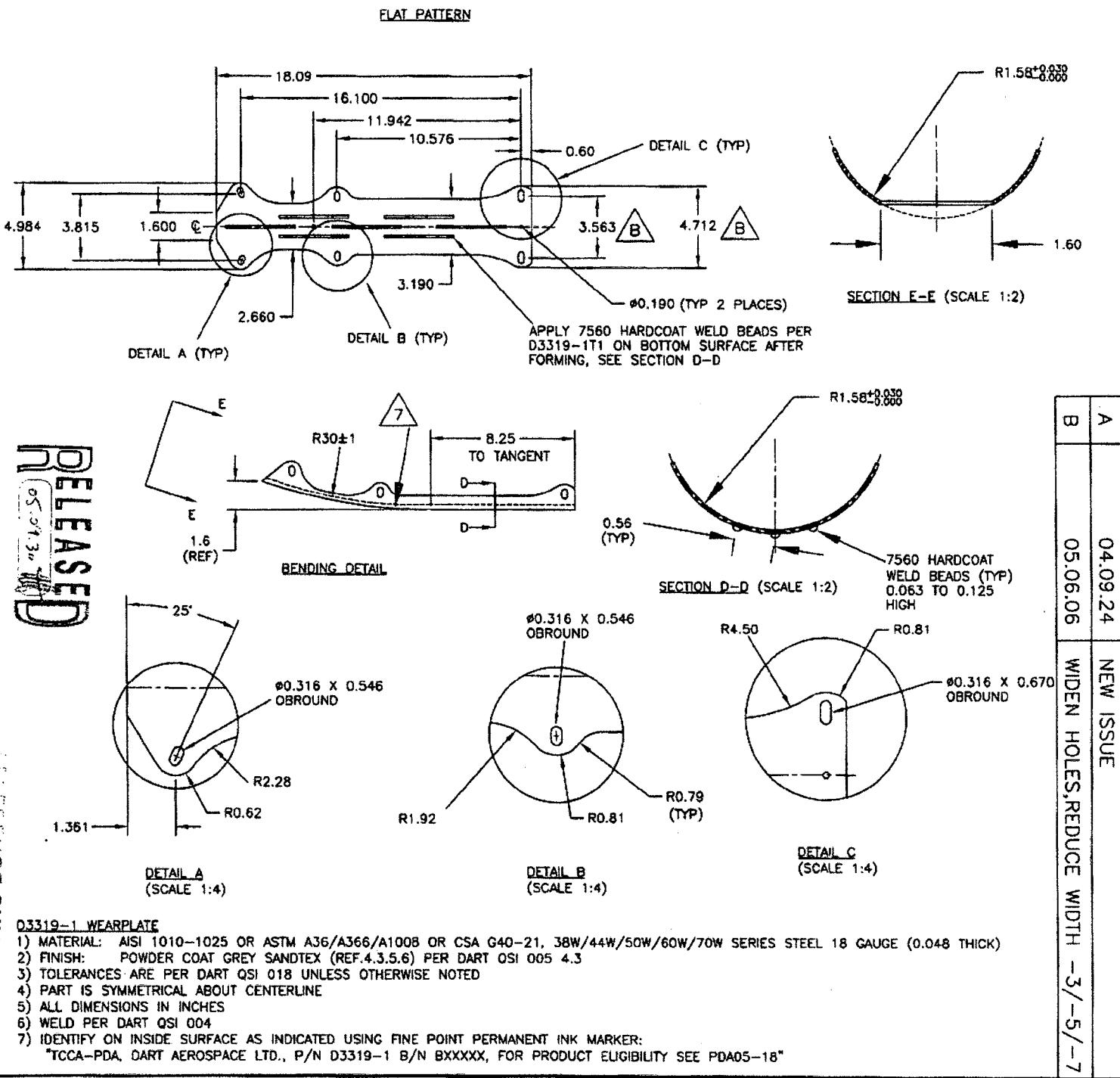


W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

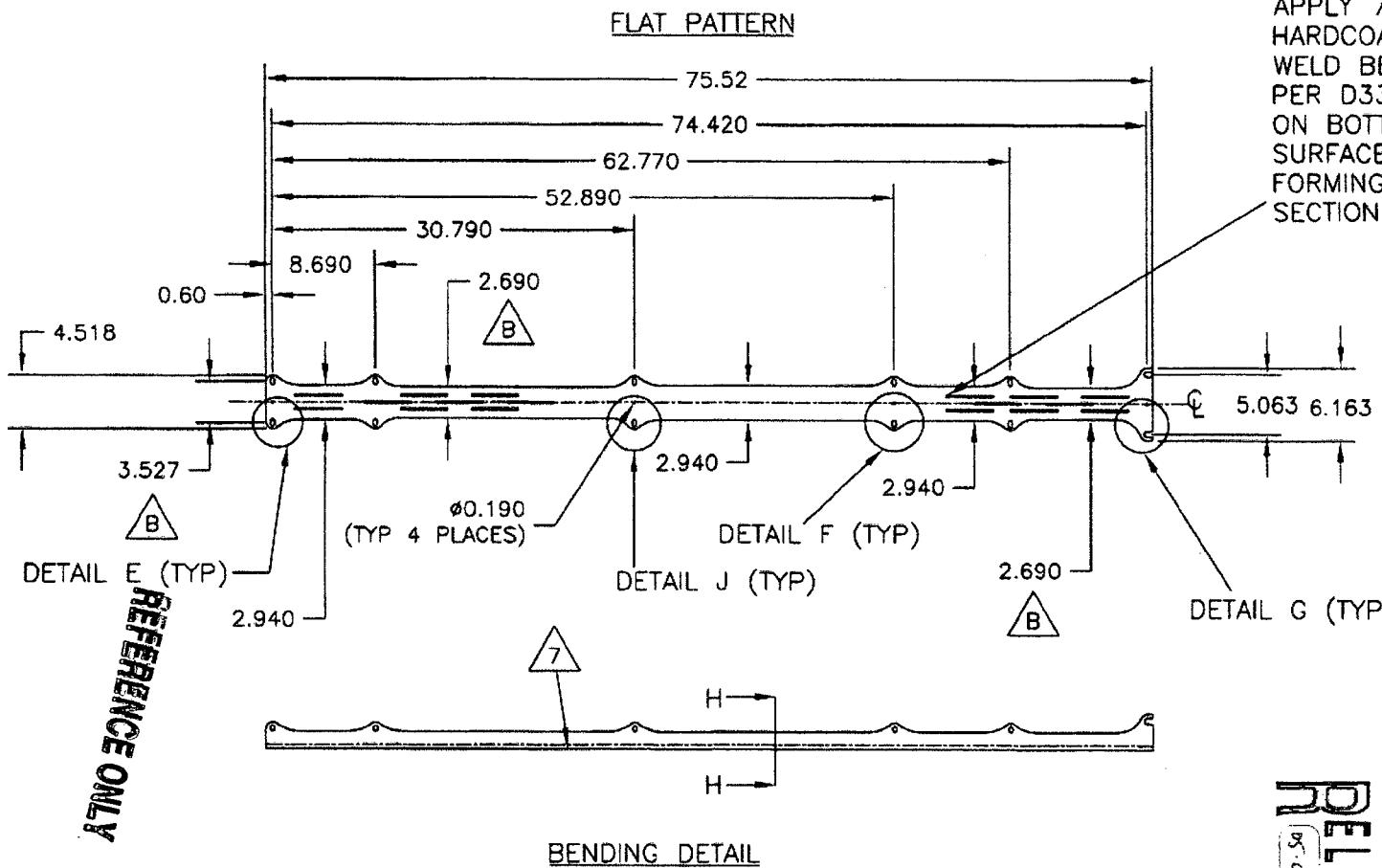
NOTE: Date & initial all entries



**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	
DATE		DRAWING NO.	REV. B
05.06.06	#	D3319	
A	#	04.09.24	
B	#	05.06.06	
		NEW ISSUE	
		WEARPLATE	
		TITLE	
		D3319	
		SCALE	
		1:8	
		SHEET 1 OF 5	

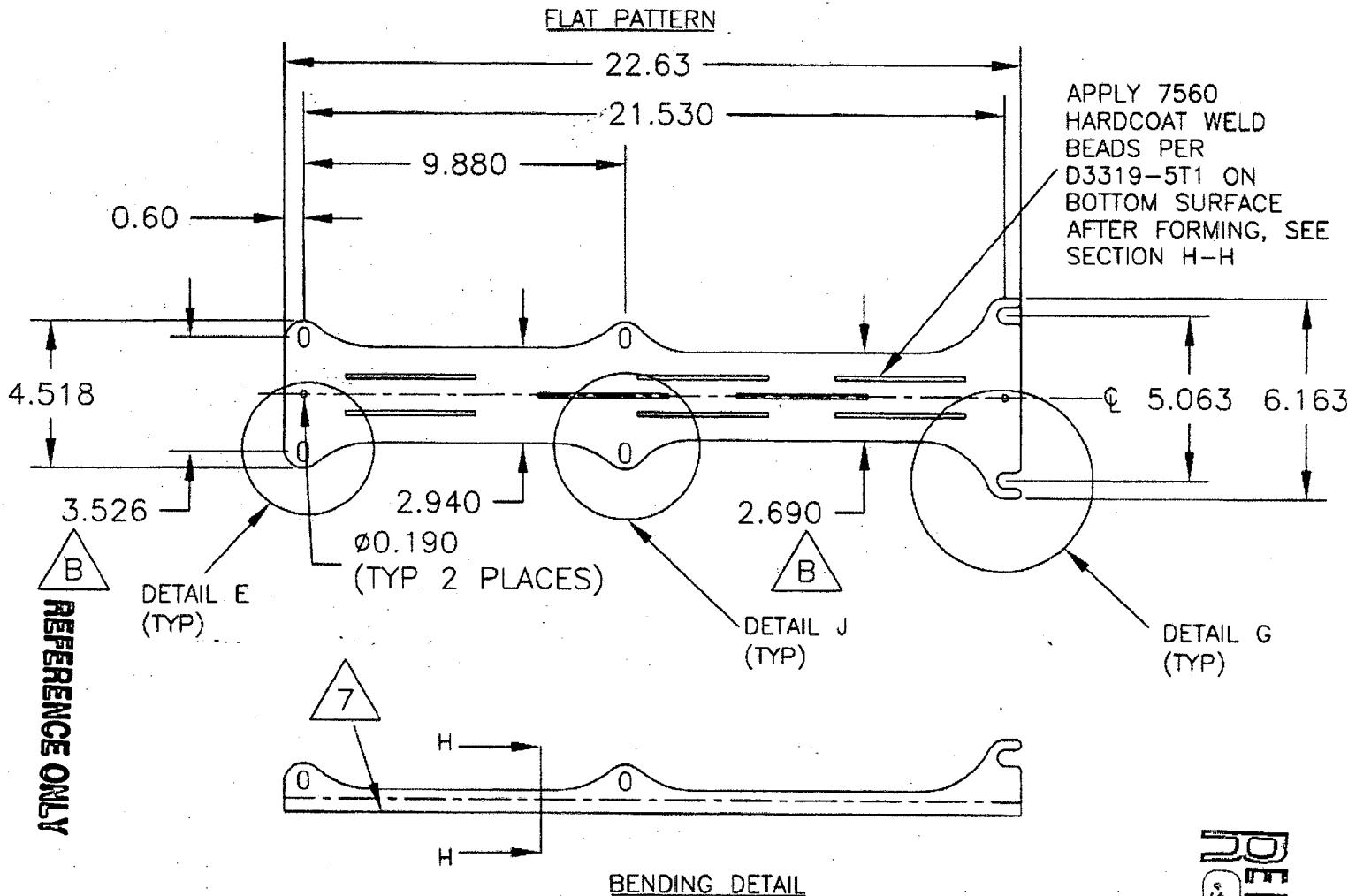
REFERENCE ONLY



DESIGN	DRAWN BY	DART AEROSPACE LTD
PF	PF	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3319
DATE	TITLE	SCALE
05.06.06	WEARPLATE	1:15

RELEASED  
05.06.06

**REFERENCE ONLY**



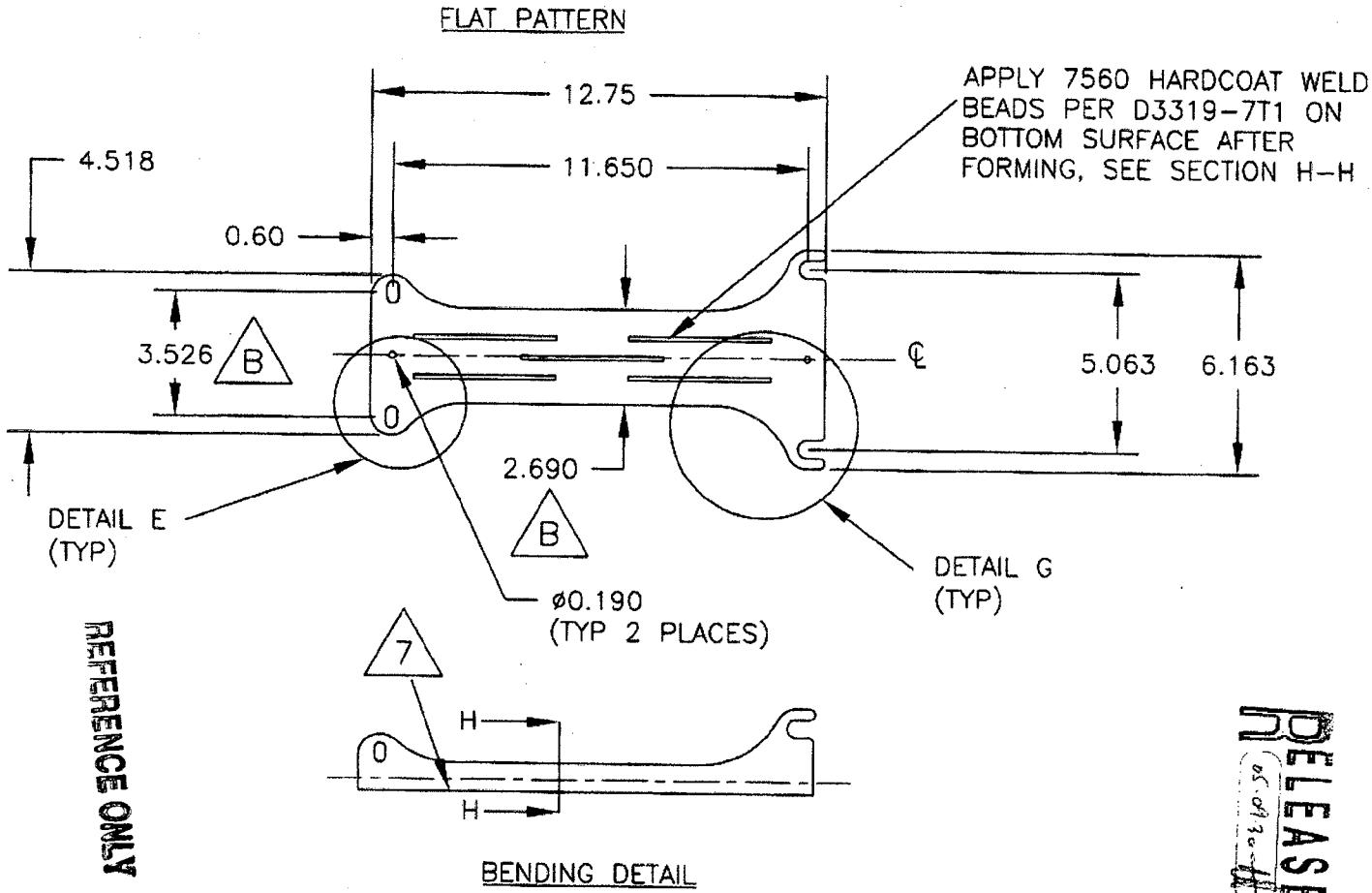
D3319-5 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-5 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE PDA05-18"



DESIGN D41	DRAWN BY P44	DART AEROSPACE LTD	
CHECKED H	APPROVED H	DRAWING NO. D3319	HAWKESBURY, ONTARIO, CANADA
DATE 05.06.06		TITLE WEARPLATE	REV. B
SHEET 3 OF 5			1.5

**RELEASED**  
05.06.06



REFERENCE ONLY

D3319-7 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-7 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

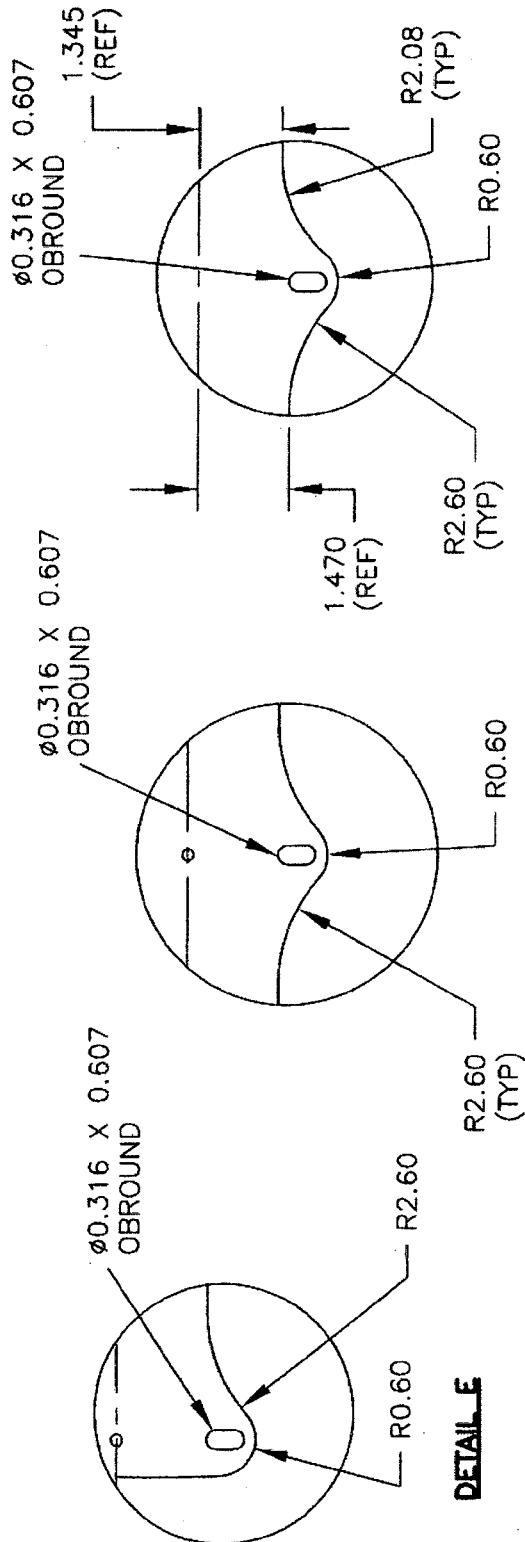
**DART**

DESIGN P/N	DRAWN BY P/N	APPROVED P/N	DRAWING NO. D3319	REV. B
DATE 05.06.06	TITLE WEARPLATE	SHEET 4 OF 5	SCALE 1:5	

**RELEASED**  
05.06.06

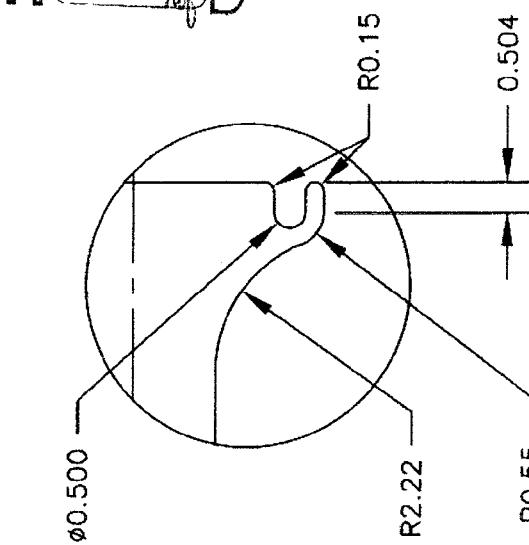
**DART**

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CH</i>	APPROVED <i>CH</i>	DRAWING NO. D3319	REV. B SHEET 5 OF 5
DATE 05.06.06	TITLE WEARPLATE	SCALE 1:3	

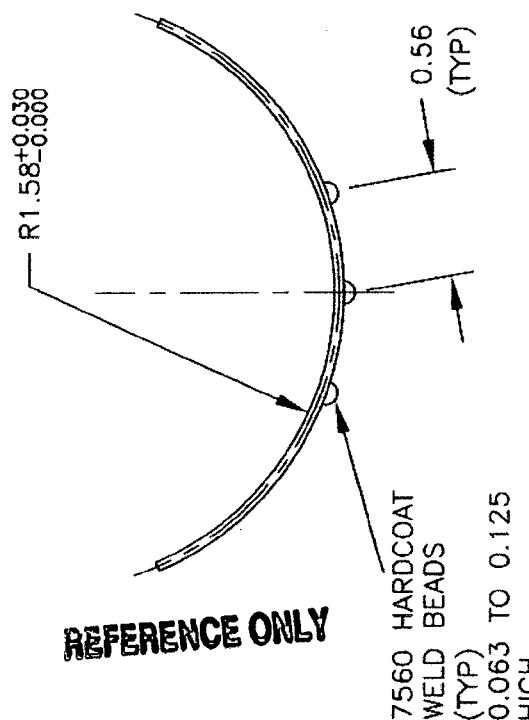


**RELEASED**  
*(05.09.30)*

**DETAIL J**



**DETAIL G**



DART AEROSPACE LTD	Work Order:	23342
Description: Wearplate	Part Number:	3319-5
Inspection Dwg:	Rev: B	Page 1 of 1

# **FIRST ARTICLE INSPECTION CHECKLIST**

## **x First Article      x Prototype**

Measured by:	<u>M. M.</u>
Date:	06/08/28

Audited by:	
Date:	06-08-29

<b>Prototype Approval:</b>	<i>N/A</i>
<b>Date:</b>	

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A		New Issue	KJ/JLM	